

Date: Monday, 2/20/2006 8:03:19 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FITTING
 Job Number : 25881
 Estimate Number : 10869
 P.O. Number : NIA Part Number : D32161
 This Issue : 2/20/2006 S.O. No. : NIA Drawing Number : D3216 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : 25480 Material : NIA
 Due Date : 2/27/2006 Qty: 50 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE DATE & USER
 Comment : Est: A 03.10.28 New Issue KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 614

Email or Ship DXF file to vendor

Laser Cut D3216-1 Fitting as per Dwg D3216

Material release note is required

u

06-02-20

50

2.0 D32161F Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Fitting

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

Pc 5/2/24

60

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-02-24

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

SP 04/02/28

30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/03/01
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/20/2006 8:03:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 25881

Part Number: D32161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57414

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



06-03-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

11/21/2005 15:06 OLBERT METAL SALES
OLBERT METAL SALES LIMITED
WILKINSON STEEL AND METALS PO/RA PS1020PC002V
 STAINLESS COIL 304
 11 GA (116" x 119") X 48.0000"
 PART NO.

ILC PO 110913
 Dart PO 614

985 795 1320 P.02/2
 BL VA 000504-001 20Oct05
 Pg 1/1



Certified in accordance to Pressure Equipment Directive 97/23/EC Annex L
 Paragraph 4.3 by TÜV Auftrags Technik GmbH (Notified Body Identification No. 0035)
 Inspection Certificate EN10204-3.1B

Shanxi Taigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 Jiancaoping, Taiyuan, Shanxi, P.R.China
 TEL: (0351)3013328 FAX: (0351)3017816
 http://www.tisco.com.cn
 E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

| | | |
|-----------------|----------------------|------------------|
| MATERIAL | AISI304 No.2B Finish | |
| SPECIFICATION | ASTM A240/A480 | ASME SA240/SA480 |
| L/C NO. | | |
| CERTIFICATE NO. | 20050636 | |
| DATE OF ISSUE | 11 | |

CUSTOMER
OLBERT

CONTRACT NO.
 1149

DATA OF
 2005/06/20

| | | | |
|---------|-----------------|-------------------|-----------------------------------------|
| Product | Melting furnace | Inspector's stamp | Mark of the Manufacturer |
| COIL | 4-VOD | | Shanxi Taiyuan Stainless Steel Co., Ltd |

| NO. | Heat No. | Coil No. | Quantity | Dimensions | Weight (kg) |
|-----|----------|-------------|----------|---------------|-------------|
| 8 | QBP1133 | 5A4-278-12B | 1 | 20GA x 48 x C | 8528 |
| 9 | Y501898 | 5A4-419-12Y | 1 | 14GA x 48 x C | 5196 |
| 10 | 4501977 | 5A4-348-12B | 1 | 11GA x 48 x C | 5182 |
| 11 | 4501969 | 5A4-416-12Y | 1 | 14GA x 48 x C | 7709 |
| 12 | 4501968 | 5A4-415-12Y | 1 | 14GA x 48 x C | 7495 |
| 13 | 4501965 | 5A4-367-12D | 1 | 11GA x 48 x C | 8127 |
| 14 | 4500491 | 5A5-18-12J | 1 | 20GA x 48 x C | 7668 |

Chemical Composition

| Heat No. | C | Si | Mn | P | S | Cr | Ni | Cu | Al | Mo | N |
|----------|-------|-------|-------|-------|-------|--------|-------|----|----|----|-------|
| QBP1133 | 0.049 | 0.470 | 1.090 | 0.023 | 0.003 | 18.340 | 8.050 | | | | 0.039 |
| Y501898 | 0.058 | 0.430 | 1.000 | 0.029 | 0.004 | 18.420 | 8.070 | | | | 0.066 |
| 4501977 | 0.070 | 0.470 | 1.310 | 0.019 | 0.002 | 18.050 | 8.100 | | | | 0.050 |
| 4501969 | 0.030 | 0.430 | 1.270 | 0.018 | 0.002 | 18.020 | 8.010 | | | | 0.050 |
| 4501968 | 0.060 | 0.460 | 1.350 | 0.018 | 0.003 | 18.120 | 8.100 | | | | 0.050 |
| 4501965 | 0.050 | 0.440 | 1.320 | 0.019 | 0.002 | 18.140 | 8.090 | | | | 0.050 |
| 4500491 | 0.050 | 0.500 | 1.340 | 0.020 | 0.002 | 18.040 | 8.060 | | | | 0.050 |

Mechanical Properties

| Ten No. | Tensile R _m N/mm ² | R _{0.2} Yield _{0.2%} N/mm ² | R _{0.01} Yield _{0.01%} N/mm ² | Elongation A5% | Corrosion Tests | Hardness | | |
|-----------|---------------------------------------------|-------------------------------------------------------------|---------------------------------------------------------------|-------------------|--------------------|----------|-----|-----|
| | | | | | | HRB | HV | HRC |
| QBP1133-T | 670 | 290 | | 55 | | | 175 | |
| Y501898-T | 665 | 289 | | 60 | | 83 | | |
| 4501977-T | 645 | 279 | | 60 | | 86 | | |
| 4501969-T | 655 | 298 | | 61 | | 84 | | |
| 4501968-T | 650 | 294 | | 58 | | 84 | | |
| 4501965-T | 690 | 283 | | 60 | | 85 | | |
| 4500491-T | 660 | 329 | | 60 | | | 172 | |

Surface and dimensions controlled: O.K.

Work Inspector: *[Signature]*

Page: 2 of 3

[Signature]
 06-2-24

[Signature]
 P.O. 614